

SPLIT-2 <sup>CL</sup>

Work Order ID 76211-1

\*76211\*

Page 1

Item ID: D3401-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Tow Cap Assembly

Start Date: 11/7/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3401

Rev B

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks 4.20" Long

SD 11/11/28

12 φ

110

0.00

\*110\*

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn as per Folio FA532 &amp; Dwg D3401

Folio Rev: \_\_\_\_\_

Dwg Rev: \_\_\_\_\_

Deburr

SD 11/11/28

12 φ

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SD 11/11/28

12 φ



Monday, November 07, 2011 2:42:13 PM

\*76211\*

Page 3

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

**Customer:**

**Start Date:** 11/7/2011      **Start Qty:** 6.00

\*6\*

Required Date: 11/16/2011      Req'd Qty: 6.00

\*6\*

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

[illegible]

150

0.00

\*150\*

## Small Fab

### Small Fab

## Memo

0.00

## Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

SB 11/12/21

12

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

## Memo

0,00

$$\delta_{a_1, 2/a_1}$$

### Quality Control

42

170

Chemical Conversion Coat per QSI005 4.1

0.00

\*170\*

HandFinish

## Memo

0.00

### Hand Finishing

① ~~1/m~~ 11-12-21 (12)

# Work Order ID 76211

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**\*76211\***

Page 4

Item ID: D3401-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Tow Cap Assembly

Stop **\*NS2\***

Start Date: 11/7/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							

**\*180\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

2:00  
320 OF

2:30

12X4M-11/12/22

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Quality Control

Memo

0.00

1X  
12 d 11/12/18  
counted

195

Assemble as per dwg

0.00

**\*195\***

HandFinish

Hand Finishing

Memo

0.00

1X  
12 d 11/12/18  
counted



# Work Order ID 76211

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**\*76211\***

Page 5

Item ID: D3401-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Tow Cap Assembly

Stop **\*NS2\***

Start Date: 11/7/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200 QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

210 Identify as per dwg & Stock Location: FP-2

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

220 QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

12/1/18

12-01-18

# Picklist Print

Monday, November 07, 2011 2:42:17 PM

Page 1

Work Order ID: 76211

Parent Item: D3401-041

Parent Item Name: Tow Cap Assembly

\*76211\*

\*D3401-041\*

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1330C3KB116		Purchased	No			100	Each	678.0000	4	244		12/6/11	
*NAS1330C3KB116*										**			
Insert													

## Location

## Loc Qty

## Loc Code

ST276

678

102606

200

103185

36

103337

442

M6061T6R3.500

Purchased

No

200

f

20.6970

0.35

2.210526

\*M6061T6R3 500\*

6061 RD bar 3.50

\*\*

## Location

## Loc Qty

## Loc Code

MAT005

15.027

116808

3.027

119231

12

MAT036

5.67

110993

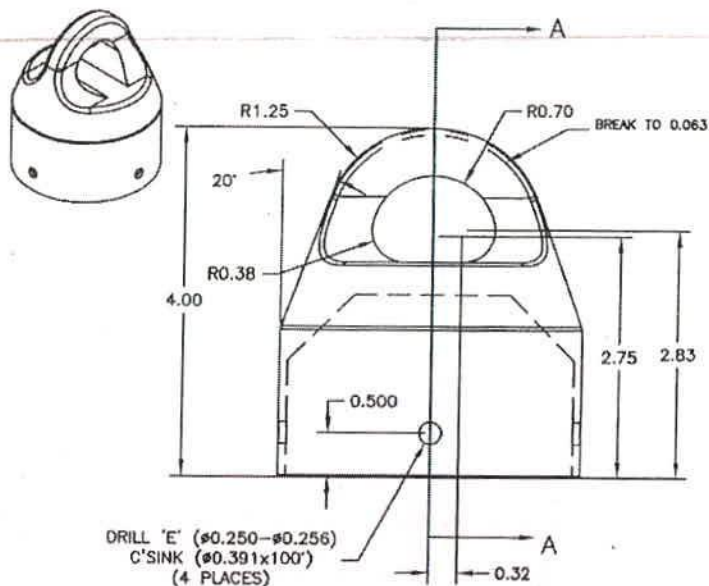
5.67



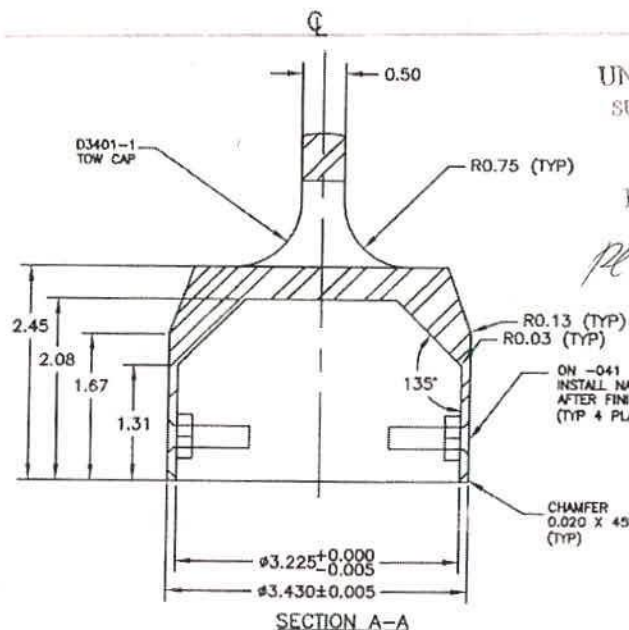


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**D3401-1 TOW CAP**



**D3401-1/-041 TOW CAP**

**D3401-1 TOW CAP**

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6  $\phi$ 3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D3401-041 TOW CAP**

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

**D3401-041 TOW CAP PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

SHOP COPY

RETURN TO:

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO A MEMORANDUM

WITHOUT NOTICE

WORK ORDER

NO. 76211

11-11-07

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3401
DATE	TITLE	REV. B
05.06.09	TOW CAP	SHEET 1 OF 1
A	05.02.24	SCALE 1:2
B	05.06.09	CHAMFER INSIDE, REMOVE RADIUS

RELEASED  
05-08-09